

5105

DART AEROSPACE LTD	Work Order:	22235
Description: Arm	Part Number:	D3387-2
D3387		D2802-2
Dwg: D2802 rev. A <i>B.A. 05.01.25</i>	Qty:	2

up 05.01.25

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O 17.800"	<i>HA</i>	05.01.17	2
2	METAL	Cut blanks 15.800 long Material: 6061-T6 bar 6.00" x 0.50" Batch: <i>119601 111409 111768</i>	<i>ML</i>	05.01.18	2
3	HAAS	Machine as per folio FA101	<i>ML</i>	05.01.19	2
4	CNC-CELL	Counter sink .375 dia as per dwg	<i>ML</i>	05.01.19	2
5	QC	Inspect Level 2	<i>ML</i>	05.01.19	2
6	QC	Inspect Level 8	<i>ML</i>	05.01.19	2
7	METAL	Tumble & Deburr NO sharp edges.	<i>GA</i>	05.01.20	2
8	QC	Inspect Level 5	<i>ML</i>	05.01.20	2
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	<i>PD</i>	05-01-20	2
10	STORES	Identify and stock	<i>PD</i>	05-01-20	2
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <i>122.13</i> <i>54c 05/01/21</i> (2) 72.86	<i>HA</i>	05.01.21	2

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	<i>02-03-18</i>

RELEASED

02/03/18 *18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgt	Approval QC Inspector
05.01.18	2	Permanent change	<i>[Signature]</i>	05.01.18	N/A	<i>[Signature]</i> 05.01.18	<i>[Signature]</i> 05.01.27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.19	3	1 piece scrap 1 time to run the program	<i>[Signature]</i> 05.01.19	destroy & replace	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19

Part No: ~~D2802~~

PAR #: _____

Fault Category: _____

NCR: Yes ☒ No ☐DQA: *[Signature]*

Date: 05.01.19

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD		Work Order: 22235
Description: Arm		Part Number: D2802 D3397-2
Inspection Dwg: D2802 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	± 0.010	0.503	—		Vern	
7.577	± 0.010	7.580	—		H-G	
R0.030	± 0.010	R0.030	—		R-G	
$\varnothing 0.191$	± 0.005 ± 0.000	$\varnothing 0.194$	—		Vern	
1.700	± 0.010	1.706	✓		Vern	
0.188	± 0.010	0.189	✓		Vern	
11.405	± 0.010	11.405	✓		Vern	
$\varnothing 0.507$	± 0.006 ± 0.001	$\varnothing 0.5067$	✓		Micro/T-6	
2.033	± 0.005	2.032	—		Vern	
R0.300	± 0.010	R0.300	✓		R-G	
1.000	± 0.005	1.003	—		Vern	
2.000	± 0.010	2.000 2.005	✓		Vern	
1.347	± 0.005	1.347	—		Vern	
0.250	± 0.010	0.250	✓		Vern	
R0.125	± 0.010	R0.125	✓		Vern	
0.125	± 0.010	0.128	✓		Vern	
R0.032	± 0.010	R0.032	—		R-G	
$\varnothing 0.375 \times 100^\circ$	± 0.010	$\varnothing 0.377$	—		Vern	
0.500	± 0.010	0.500	✓		Vern	
0.300	± 0.010	0.300	—		Vern	

Measured by: <i>gmk</i>	Audited by: <i>Er</i>	Prototype Approval: <i>Q</i>
Date: 05/01/19	Date: 05/01/19	Date: 05.01.19
Rev A	Change New Issue	Revised by KJ/JLM Approved

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
10:23 am

Work Order No : 0022235
Project Name : D2802-2
Project For : WK505
Work Order Type : Main
Main WO Number :
House Part Number : D2802-2
Description : Arm
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 01-17-05
Est Finish Date : 01-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00